Work Order Tuesday, July 29,				*12	3107*					<u> </u>	Page 1
Revision ID: Item Name:	O3560-1 Arm 7/29/14	Start Qty: 5.00 Req'd Qty: 5.00	*5* *5*	Accept	*N900 Cust Item Customer:		100	ገ*	Setup Sta		IS1* IS2*
Reference: Approvals:	Process Pla	an: TA	Date: 14/0713	e Tooling		ate:	_	ļ	Run Sta	<sup>rt</sup> * \	JR1*
	QC:			SPC (Y/N):		ate:			Sto	, *V	IR2*
Sequence ID/ Work Center ID		Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Numbe	Insp. r Stamp
Draw Nbr	Re	vision Nbr				i.			-		
D3560	Rev	v D									
100 <b>*1</b> Bandsaw		BAND SAW  Memo		0.00		Marin Sa		5			12/02/
Jeaspa Bandsaw			s 16.750" long	•							:
•		•		,	·					\$ 3	
*110		HAAS CNC VERTIC	AL MACHINING #1	0,00	of Dula	./-	,	5	<i>O</i>		: , 
HAAS 1 HAAS CNC vertical t	machine #1	2-C'sink	per Folio FA693 Rev: AD 1.196" hole on manual mill a per dwg D3560	0.00 & Dwg D3560 Rev: _ s per dwg D3560	D 7 14/00	/3 -					
120։ *1 <b>2Ո</b> *		QC2- Inspect parts of	machine FAI/FAIB	0.00	HYOA)s			5			
QC · Quality Control		Memo		0.00	( 1370						-
* 121 Millo Conv. C. Sink & 0.3	85 × 100°							5	<u>Ø</u>		JC-L-01 14/09/10

DQA:		_ Date:											"DART
		_			WORK ORDER NON-	·CC	ONFO	RMANCE / U					AEROSPACE
QA Closed:		Date:							V	vork O	raer u	odate only	
Work Orde	r·				DISPOSITION				AGAINST E	EPART	MENT	/PROCESS	
Work Orde	··				Rework			Skid-tube	Crosstube	٦		Water Jet	Engineering
Part N	0.				Scrap		1	Machining	Small Fab		Pro	d. Eng. Coor.	Quality
	-				Use-as-is		Thern	noforming	Finishing	☐ R	ec/Sto	re/Packaging	Other
NCR N	o				Suspected Unapproved			Large Fab	Composite			Supplier	
							~						
Root				Desci	ription of work order update		nitial		tion	_	n &		
Cause	Date	Step	Qty		or non-conformance	Ch	ief Eng	Desc	ription	D	ate	Verification	QC Inspector
Design													
Doc/Data													
Equip/Tooling												ļ	
Handling/Pre													
Material		ļ											
Operator		ĺ											
Offset/Setup													
Process													
Supplier	-									į			
Training _	_									İ			
Transport				ŀ									
Unapproved	ļ		<u> </u>			EAI	IIIT CA	EGORY				<u> </u>	
Landir	ng Gear	•			General	-A	OLI CA	LGONT					
Landii	Bending			<u></u>	Bend		l <sub>Eolio/E</sub>	rogram	ſ	Outs	ide Dim	nensions	Pressure/Forced
ŀ		lot Conce	ntric	-	BOM/Route	H	Grain	10614111		-		tolerance	Set-up
ŀ	Cracks	iot conce	110110		Broken/Damage/Defect	$\vdash$	Hardwa	re		_	Incorre	<del> </del>	Temperature/Cure
	<b></b> -I	ink/Ripple	e/Wave		Burrs	<u> </u>	4	ion Incomplete/U	ngualified		Lost/M	_	Weld
ŀ	Cuffs		,		Contamination		•	ions Incomplete/	-	_	Moved		Wrong Stock Pulled
:	Crushing	Į		<u> </u>	Countersink		4	ned/off center		Posit	ioned \	Wrong	<b>-</b>
	Heat Tre				Cut Too Short		Mislabe		Ţ	Pow	er Loss/	'Surge	Other
		on Strip in	Tube		Drawing		Misrea	k	_				
	Marks/C				Drill Holes		Off-set						
		Sequence	· ·		Finish		Out of	Calibration					
	Wave/T	wist in Tu	be		Fit/Function		Out of	Sequence					

Work	<b>Order</b>	ID	123107
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\*123107\*

Page 2

Tuesday, July 2	29, 2014 2:3	0:48 PM		* 1 フ.・	31()/"						1 age 2
Item ID: Revision ID: Item Name:	D3560-1 Arm			Accept	*N900	<u> </u>	100	<b>)*</b> s	Setup Sta	17	JS1* JS2*
Start Date: Required Date Reference:	7/29/14 :: 7/29/14	Start Qty: 5.00 Req'd Qty: 5.00		5* 5*	Cust Item 1 Customer:	D:					
Approvals:	Process P	Plan:	Date:	Tooling: SPC (Y/N):		ate:		R	Run Sta Sta	^1\ op	JR1* JR <i>2</i> *
Sequence ID/ Work Center 1 130 *1 30* QC Quality Control	ID	Operation Description QC8- Inspect parts - second	ond check	Set Up/ Run Hours 0.00	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. r Stamp  DAS 44   4   6   6   6   6   6   6   6   6
210 *910* Packaging Packaging		Identify as per dwg & St <b>Memo</b>	ock Location: (	<u>U4</u> U03 0.00 0.00				Sx		_/_	DA 1-9-15 26 9-8
220 *220* QC Quality Control		QC21- Final Inspection  Memo	- Work Order Re	0.00 0.00						14/9	1/6 H)

DQA:			. Date:										•	"DART
QA Closed:			Date:			WORK ORDER NON	-CC	ONFO	RMANCE / UP		/ork Order up	odate only	$\neg$	AEROSPACE
QA closed.			Dute.			DISPOSITION					EPARTMENT/			U-10-10-10-10-10-10-10-10-10-10-10-10-10-
Work Ord	er:					DISPOSITION				AGAINSI D	=-	- FROCESS		
	•					Rework		i	Skid-tube	Crosstube		Water Jet		Engineering
Part i	١o.					Scrap			Machining	Small Fab		d. Eng. Coor.	_	Quality
						Use-as-is		Therr	noforming	Finishing	Rec/Stor	e/Packaging	_	Other
NCR I	۱o.		- 11111	******		Suspected Unapproved	]		Large Fab	Composite		Supplier		
Root					Desc	ription of work order update	П	nitial	Acti	on	Sign &			
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descri	ption	Date	Verification	1	QC Inspector
Design														
Doc/Data														
Equip/Tooling														
Handling/Pre	ધદ													
Material	A					•								
Operator	Ш													
Offset/Setup														
Process	Ш												-	
Supplier	Ш													
Training	_													
Transport	$\sqcup$													
Unapproved				l	<u> </u>		<u> </u>	LUT CA	TECORY		<u>l</u>			<del></del>
		<u>.</u>				C	FA	OLI CA	TEGORY		4498W			
Landi		1				<b>General</b> Bend	_	Teolio/s	Program	Г	Outside Dim	ensions [	7	Pressure/Forced
		Bending	at Cansar	a+ria	-	BOM/Route	-	Grain	riogram	<u> </u>	Over/Under	The state of the s	-	Set-up
		Centre No Cracks	or conce	IIIIC		Broken/Damage/Defect	$\vdash$	Hardwa	aro	-	Part Incorred	t t	_	Temperature/Cure
		Cracks Crimp/Kit	nk/Binnla	Mayo		Burrs	$\vdash$	-4	tion Incomplete/Un	qualified	Part Lost/Mi	ŀ	—	Weld
	-	Cuffs	rik/ Kihhie	y wave	-	Contamination	$\vdash$	-	tions Incomplete/U		Part Moved	.55.1.16		Wrong Stock Pulled
	<u> </u>	Crushing			├	Countersink	$\vdash$	-	gned/off center	-	Positioned V	ا Vrong	`	
,	-	Heat Trea				Cut Too Short		Mislab	-	-	Power Loss/	- r	П	Other
	H	Inspectio		Tube	-	Drawing		Misrea		<u>L</u>		<b>~</b> (		5-1-mm
	$\vdash$	Marks/Ch	-			Drill Holes		Off-set						
		Turning S				Finish		-	Calibration					
		Wave/Tw				Fit/Function		-	Sequence					

**Picklist Print** 

Tuesday, July 29, 2014 2:30:47 PM

Work Order ID: 123107

\*123107\*

Parent Item: D3560-1

\*D3560-1\*

Parent Item Name: Arm

**Start Date:** 7/29/14

Required Date: 7/29/14

Page 1

Start Qty: 5.00

\*\*

Required Qty: 5.00

**Comments:** 

IPP REV:A 13.06.03 PER DWG REV.D DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.500X05.00 0		Purchased	No				f	53.0000		8			

## \*M6061T6B0 500X05 000\*

6061-T6 Bar .500 x 5.00

<b>Location</b>	Loc Oty	Loc Code	
MAT001	53		
m127323	5		******
m129449	48		6, 979'
			· · /

DQA:			_ Date:						_				
						WORK ORDER NON	·CC	ONFO	RMANCE / UF		ark Ordar un	odata anly	AEROSPACE 7
QA Closed:			Date:							VV	ork Order up	date only	<u></u>
Work Orde	∍r·					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Work Orac	• •		·			Rework			Skid-tube	Crosstube	7	Water Jet	Engineering
Part N	No.					Scrap		1	Machining	Small Fab	Pro	d. Eng. Coor.	Quality
	•					Use-as-is			noforming	Finishing	Rec/Stor	e/Packaging	Other
NCR N	No.					Suspected Unapproved			Large Fab	Composite	]	Supplier	
Root					Desc	ription of work order update		nitial	Acti		Sign &	_	
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descr	iption	Date	Verification	QC Inspector
Design													
Doc/Data	Щ			i									
Equip/Tooling	Ш			1			1						
Handling/Pre	Щ												
Material													
Operator	Ш												
Offset/Setup													
Process	Ш												
Supplier	$\vdash$												
Training													·
Transport													
Unapproved	1	<u> </u>	1	l			FΔI	ULT CA	TEGORY		<u> </u>	<u> </u>	<del></del>
Landi	nø (	iear				General					" 17", E.		
Lana		Bending				Bend		Folio/F	Program		Outside Dim	ensions	Pressure/Forced
		•	ot Concer	ntric		BOM/Route		Grain	J		Over/Under	tolerance	Set-up
		Cracks				Broken/Damage/Defect		Hardwa	are		Part Incorre	cí 📗	Temperature/Cure
		l	nk/Ripple	/Wave		Burrs		Inspect	ion Incomplete/Ur	nqualified	Part Lost/M	issing	Weld
		Cuffs				Contamination		Instruct	tions Incomplete/U	Jnclear	Part Moved		Wrong Stock Pulled
		Crushing	- - -			Countersink		]Misalig	gned/off center		Positioned \	Wrong	_
		Heat Tre	at			Cut Too Short		Mislabe	eled		Power Loss/	'Surge	Other
		Inspectio	on Strip in	Tube		Drawing		Misrea	d				
		Marks/Cl	hatter			Drill Holes		Off-set					· · · · · · · · · · · · · · · · · · ·
		Turning S	Sequence			Finish		Out of	Calibration				
		Wave/Tv	vist in Tul	be		Fit/Function		Out of	Sequence			····	

DART AEROSPACE LTD	Work Order: 12	3107
Description: Arm	Part Number:	D3560-1
Inspection Dwg: D3560 Rev: D		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

		<del></del>		<del></del>		
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.507	+0.000/-0.001	.506	V		GagePin	
Ø0.196	+0.005/-0.001	.197	V		15	
Ø1.000	+0.010/-0.001	1.004	V		Vernies	
0.500	+/-0.010	.506	V		'(	
0.250	+/-0.010	.249	V		v	
0.275	+/-0.010	.273	V		ıi .	
0.188	+/-0.010	.185			1/	
2.000	+/-0.010	1.998	/		n	
1.700	+/-0.010	1.699	V		1	
Ø0.385 x 100°	+/-0.010 x 0.5°	0.387	V		Caliper	JCU -08 -
0.250 Deep	+/-0.010	.256	V		vernier cnc-02	

Measured by: Das

Measured by: Audited by: 9-89

Date: 14/09/05

Date: 14/09/14

Date: N/A

A 07.01.17 New Issue P/O D3560-041 KJ/JLM  B 07.06.13 Dimensions updated per Dwg Rev B KJ/JLM  C 08.07.34 Dwg Boy undeted	Rev	Date	Date Change	Revised by	Approved
B 07.06.13 Differsions updated per Dwg Rev B	Α	07.01.17	.01.17 New Issue P/O D3560-041	KJ/JLM	
C 09 07 24 Dwg Boy undeted	В	07.06.13	.06.13 Dimensions updated per Dwg Rev B		
C   00.07.24   Dwg Rev updated   R3/DD $\sim$ , x   L33	С	08.07.24	.07.24 Dwg Rev updated	KJ/DD 🛠	N/











